

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007066**Date Inspected:** 27-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai ,China**CWI Name:** Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Assembly**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector was present during the times noted above for observations relative to the work being performed.

Segment Repair Yard (South of the blast shop)

Segment 5CW

This QA inspector visually observed the preproduction stud welding test for the counterweight studs on segment 5CW. The flash on the studs exhibited 360° as per D1.5 Section 7.7.1. The two (2) studs that were welded for the preproduction test were then bent to 30° after cooling.

This QA Inspector performed Magnetic Particle testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (MT) report for this date. The members are identified as the longitudinal diaphragm attachment welds. The Weld Designations are as follows:

SEG025B-008, 011, 013, 014, and 017.

SEG025C-008, 011, 013, 014, and 017.

This QA Inspector performed Magnetic Particle testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (MT) report for this date. The members are identified as the floor beam super assembly welds. The Weld Designations are as follows:

SSD13-PP36-048~051, 109~112 and 129.

SSD13A-PP36-046~049, 107~110 and 125.

SSD14-PP35-048~051, 109~112 and 129.

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SSD14A-PP35-046~049, 107~110 and 125.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, (15000422372), who represents the Office of Structural Materials for your project.

Inspected By:	Patterson,Rodney	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
